

# Work Order ID 101421

May-10-13 9:42:52 AM

\*101421\*

Page 1

Item ID: D206-642-214

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Skidtube RH

Start Date: 5/10/13 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 5/10/13 Req'd Qty: 1.00 \*1\*

Customer:

Reference: rework

Approvals: Process Plan: W Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN-D206-642	O

100

0.00

\*100\*

DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile & type labels per PPP206-642-214 CHG004

101

0.00

\*101\*

HandFinish

Hand Finishing

Memo

0.00

PULL FROM STOCK:  
1 X D206-642-214 B45908

PER DSI9440  
REMOVE ALL OLD WEARPLATES AND DISCARD  
REPLACE WITH SS WEARPLATES

<b>DART</b>				TEL: 1-613-632-3336 FAX: 1-613-632-4443	
TRANSPORT CANADA APPROVAL # 09-39					
P/N	D206-642-214	CHG	CHG004		
DESC	Skidtube Assembly	STC	SH98-4		
LOT	B45908	STC	SA00475SE		
MODEL	Bell 206A/B	STC			
US PATENT # 5,735,484 CANADA FOREIGN PATENTS PENDING					
MADE IN CANADA					

1 x f lll 13/05/10

# Work Order ID 101421

\*101421\*

Page 2

May-10-13 9:42:52 AM

Item ID: D206-642-214

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Skidtube RH

Start Date: 5/10/13 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 5/10/13 Req'd Qty: 1.00 \*1\*

Customer:

Reference: rework

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
102 *102* QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00				1			
110 *110* Packaging Packaging	Pick Kit  Memo PER DSI 9421 REMOVE FROM KIT 1 X AN4-5A 107041 1 X AN960JD16 1 X D2655 34752 DISCARD ADD: 1 X AN4C5A B 123265 1 X AN960C416 B 123249 1 X D3413-1 B 1117	0.00  0.00							

27  
1350

13/5/1050

# Work Order ID 101421

\*101421\*

Page 3

May-10-13 9:42:52 AM

Item ID: D206-642-214 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Skidtube RH  
 Start Date: 5/10/13 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 5/10/13 Req'd Qty: 1.00 \*1\* Customer:  
 Reference: rework

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC4- 100% Inspect kits for completeness  Memo	0.00 0.00				1			
130 *130* Packaging Packaging	Packaging  Memo REPACKAGE PER PPP USING NEW B/N NEW LABELS REQ'D Identify and pack for shipping as per PPPD206-642-214 @ CHG005 Location: _____	0.00 0.00							
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							

MUS 13-05-10  
 MUS 13-05-10

# Picklist Print

May-10-13 9:42:51 AM

Page 1

Work Order ID: 101421

Parent Item: D206-642-214

Parent Item Name: Skidtube RH

Start Date: 5/10/13

Required Date: 5/10/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:K05.07.14ECN 847 & 901; Add Tow Ring and GHW KitKJ/CP/JLM  
 IPP Rev:L 07-12-04 ECN 1080p DD verified by: IPP rev M 10.02.02 per IIN rev  
 M EC verified by: JLM IPP rev N 10.11.29 per IIN rev N DD verified by: JLM IPP  
 REV:O 11.11.17 PER IIN REVO DD VERF;EC IPP Rev:P 12.11.21 ECN12-679  
 DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4G5A BOLT		Purchased	No				Each	223.0000		5.0			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST355		223							
				122599		91							
				123265		132							
AN9G6G416 washer	NAS1149C0463R	Purchased	No				Each	0.0000		123248			
D206-642-214 Skidtube RH		Manufactured	No				Each	0.0000		101421			
D3413-1 Ring		Manufactured	No				Each	99.0000		1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST421		42							
				80224		3							
				88025		1							
				96882		18							
				98167		20							
				ST464		57							
				91117		57							
D3535-13 Wearshoe		Manufactured	No				Each	13.0000		1		13/05/10	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG		2							
				86229		2							
				FP002		11							
				79850		1							
				95958		10							

# Picklist Print

May-10-13 9:42:51 AM

Page 2

Work Order ID: 101421

Parent Item: D206-642-214

Parent Item Name: Skidtube RH

Start Date: 5/10/13

Required Date: 5/10/13

Start Qty: 1.00

Required Qty: 1.00

D3535-21 Manufactured No Each 16.0000  
Wearshoe

Location	Loc Qty	Loc Code
FP002	16	
86231	3	
98920	13	

1 13/05/10

D3535-33 Manufactured No Each 6.0000  
Wearshoe

Location	Loc Qty	Loc Code
FP002	6	
70462	1	
78984	5	

1 13/05/10

D3536-13 Manufactured No Each 11.0000  
Gasket

Location	Loc Qty	Loc Code
FG	6	
81344	2	
89686	4	
FP001	5	
95875	5	

1 13/05/10

D3536-21 Manufactured No Each 18.0000  
Gasket

Location	Loc Qty	Loc Code
FP001	18	
78966	1	
83433	2	
98910	2	
99286	13	

1 13/05/10

D3536-33 Manufactured No Each 7.0000  
Gasket

Location	Loc Qty	Loc Code
FP001	7	
86252	7	

1 13/05/10

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Shop Packet Print

Page 2



## List Lots

Page 1 of 1

May-10-13 9:13:33 AM

Criteria : Item ID: d206-642-214 All Locations All Warehouses All Quantity

Item ID Item Name	Warehouse ID Location ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt	Lot Code	Type Code	Comments
D206-642-214 Skidtube RH	Main Warehouse FG082	45908	9/25/12	1.0000		QC21	CHG004	
Total:				1.0000				

# **DART SERVICE INSTRUCTION**

**TO AMEND INSTALLATION INSTRUCTIONS D206-642 REV. L AND  
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-642 REV. 1**

**REF. CANADIAN STC: SH98-4**

**REF. FAA STC: SA00475SE**

**REF. EASA STC: EASA.IM.R.S.01320**

## **INSTRUCTIONS:**

1) FOR D206-642-111/-112/-211/-212/-213/-214 SKIDTUBES @ CHANGE 005 AND SUBSEQUENT, MODIFY THE FOLLOWING:

- a) REPLACE THE CARBON STEEL WEAR PADS AND WEARSHOES WITH STAINLESS STEEL WEARPADS AND WEARSHOES PER THE UPDATED PARTS LIST ON SHEET 2.
- b) ADD NEOPRENE GASKETS BETWEEN THE SKIDTUBE AND WEARSHOES PER THE UPDATED PARTS LIST ON SHEET 2 AND PER FIGURE 1 ON SHEET 4.
- c) REPLACE THE CARBON STEEL FASTENERS FOR THE WEARPADS AND WEARSHOES WITH STAINLESS STEEL FASTENERS PER THE UPDATED PARTS LIST ON SHEET 2.
- b) AMEND THE PARTS LIST IN SECTIONS 4.1 AND 4.2 OF INSTALLATION INSTRUCTIONS D206-642 REV. L OR EARLIER AND SECTIONS 32.10 AND 32.11 OF THE INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-642 REV. 1 OR EARLIER AS SHOWN ON SHEET 2.

2) FOR D206-642-311/-312/-411/-412 SKIDTUBES @ CHANGE 006 AND SUBSEQUENT, MODIFY THE FOLLOWING:

- a) REPLACE THE CARBON STEEL WEAR PADS AND WEARSHOES WITH STAINLESS STEEL WEARPADS AND WEARSHOES PER THE UPDATED PARTS LIST ON SHEET 3.
- b) ADD NEOPRENE GASKETS BETWEEN THE SKIDTUBE AND WEARSHOES PER THE UPDATED PARTS LIST ON SHEET 3 AND PER FIGURE 2 ON SHEET 4.
- c) REPLACE THE CARBON STEEL FASTENERS FOR THE WEARPADS AND WEARSHOES WITH STAINLESS STEEL FASTENERS PER THE UPDATED PARTS LIST ON SHEET 3.
- d) AMEND THE PARTS LIST IN SECTIONS 4.3 AND 4.4 OF INSTALLATION INSTRUCTIONS D206-642 REV. L OR EARLIER AND SECTIONS 32.12 AND 32.13 OF THE INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-642 REV. 1 OR EARLIER AS SHOWN ON SHEET 3.

B	P/N CORRECTION	AJS	09.03.25
A	NEW ISSUE	AJS	08.12.19
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<del>JS</del>	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9440	SHEET 1 OF 4
APPROVED	<del>JS</del>	TITLE	SCALE
DE APPR.	<del>JS</del>	WEARSHOE CHANGE	NTS
DATE	09.03.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



4.1 206 A/B Low Gear Skidtubes (D206-642)  
32.10 206 A/B Low Gear Skidtubes (ICA-D206-642)

ITEM	Qty -111	Qty -112	Qty -141	Qty -147	PART NUMBER	DESCRIPTION
	X				D206-642-111	SKIDTUBE INSTALLATION, LH
		X			D206-642-112	SKIDTUBE INSTALLATION, RH
	1	1	X		D206-642-141	SKIDTUBE
				X	D206-642-147	WEARSHOE KIT (REPLACES -143)
	1	1			D206-651-041	* 206 GHW ADAPTER <sup>(b)</sup>

IS:

20A			4		D3537-1	WEARPAD (REPLACES D2648-3)	(MODIFY)
21A			1		D3537-3	WEARPAD (REPLACES D3429-1)	(MODIFY)
22A			1	1	D3535-11	WEARSHOE (REPLACES D2656-11)	(MODIFY)
22B			1	1	D3536-11	GASKET	(ADD)
23A			1	1	D3535-21	WEARSHOE (REPLACES D2656-21)	(MODIFY)
23B			1	1	D3536-21	GASKET	(ADD)
24A			1	1	D3535-31	WEARSHOE (REPLACES D2656-31)	(MODIFY)
24B			1	1	D3536-31	GASKET	(ADD)
26A			42		MS27039-1C08	SCREW	(MODIFY)
26B			42		AN960C10L	WASHER	(MODIFY)

WAS:

20A			4		D2648-3	WEARPAD
21A			1		D3429-1	WEARPAD
22A			1	1	D2656-11	WEARSHOE
23A			1	1	D2656-21	WEARSHOE
24A			1	1	D2656-31	WEARSHOE
26A			42		MS27039-1-08	SCREW
26B			42		AN960JD10L	WASHER

4.2 206 A/B High Gear Skidtubes (D206-642)  
32.11 206 A/B High Gear Skidtubes (ICA-D206-642)

ITEM	Qty -211	Qty -212	Qty -213	Qty -214	Qty -241	Qty -247	PART NUMBER	DESCRIPTION
	X						D206-642-211	SKIDTUBE INSTALLATION, LH
		X					D206-642-212	SKIDTUBE INSTALLATION, RH
			X				D206-642-213	SKIDTUBE INSTALLATION, LH, THRU BOLT
				X			D206-642-214	SKIDTUBE INSTALLATION, RH, THRU BOLT
	1	1	1	1	X		D206-642-241	SKIDTUBE
						X	D206-642-247	WEARSHOE KIT (REPLACES -243)
	1	1	1	1			D206-651-041	* 206 GHW ADAPTER <sup>(b)</sup>

IS:

20A					4		D3537-1	WEARPAD (REPLACES D2648-3)	(MODIFY)
21A					1		D3537-3	WEARPAD (REPLACES D3429-1)	(MODIFY)
22A					1	1	D3535-13	WEARSHOE (REPLACES D2656-13)	(MODIFY)
22B					1	1	D3536-13	GASKET	(ADD)
23A					1	1	D3535-21	WEARSHOE (REPLACES D2656-21)	(MODIFY)
23B					1	1	D3536-21	GASKET	(ADD)
24A					1	1	D3535-33	WEARSHOE (REPLACES D2656-33)	(MODIFY)
24B					1	1	D3536-33	GASKET	(ADD)
26A					44		MS27039-1C08	SCREW	(MODIFY)
26B					44		AN960C10L	WASHER	(MODIFY)

WAS:

20A					4		D2648-3	WEARPAD
21A					1		D3429-1	WEARPAD
22A					1	1	D2656-13	WEARSHOE
23A					1	1	D2656-21	WEARSHOE
24A					1	1	D2656-33	WEARSHOE
26A					44		MS27039-1-08	SCREW
26B					44		AN960JD10L	WASHER

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
DRAWN	AJS	
CHECKED		DRAWING NO. REV. B
MFG. APPR.	N/A	DSI 9440 SHEET 2 OF 4
APPROVED		TITLE SCALE
DE APPR.		WEARSHOE CHANGE NTS
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4.3 206 L/L-1/L-3/L-4/407 Low Gear & 407 High Gear Skid tubes (D206-642)  
32.12 206 L/L-1/L-3/L-4/407 Low Gear & 407 High Gear Skid tubes (ICA-D206-642)

ITEM	Qty -311	Qty -312	Qty -341	Qty -347	Qty -013	PART NUMBER	DESCRIPTION
	X					D206-642-311	SKIDTUBE INSTALLATION, LH
		X				D206-642-312	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-341	SKIDTUBE
				X		D206-642-347	WEARSHOE KIT (REPLACES -343)
	1	1			X	D206-648-013	GROUND HANDLING KIT

IS:

20A			6			D3537-1	WEARPAD (REPLACES D2648-3)	(MODIFY)
21A			1			D3537-3	WEARPAD (REPLACES D3429-1)	(MODIFY)
22A			1	1		D3535-11	WEARSHOE (REPLACES D2656-11)	(MODIFY)
22B			1	1		D3536-11	GASKET	(ADD)
23A			1	1		D3535-23	WEARSHOE (REPLACES D2656-23)	(MODIFY)
23B			1	1		D3536-23	GASKET	(ADD)
24A			1	1		D3535-35	WEARSHOE (REPLACES D2656-35)	(MODIFY)
24B			1	1		D3536-35	GASKET	(ADD)
26A			54			MS27039-1C08	SCREW	(MODIFY)
26B			54			AN960C10L	WASHER	(MODIFY)

WAS:

20A			6			D2648-3	WEARPAD
21A			1			D3429-1	WEARPAD
22A			1	1		D2656-11	WEARSHOE
23A			1	1		D2656-23	WEARSHOE
24A			1	1		D2656-35	WEARSHOE
26A			54			MS27039-1-08	SCREW
26B			54			AN960JD10L	WASHER

4.4 206L/L-1/L-3/L-4 High Gear Skid tubes (D206-642)  
32.13 206L/L-1/L-3/L-4 High Gear Skid tubes (ICA-D206-642)

ITEM	Qty -411	Qty -412	Qty -441	Qty -447	Qty -013	PART NUMBER	DESCRIPTION
	X					D206-642-411	SKIDTUBE INSTALLATION, LH
		X				D206-642-412	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-441	SKIDTUBE
				X		D206-642-447	WEARSHOE KIT (REPLACES -443)
	1	1			X	D206-648-013	GROUND HANDLING KIT

IS:

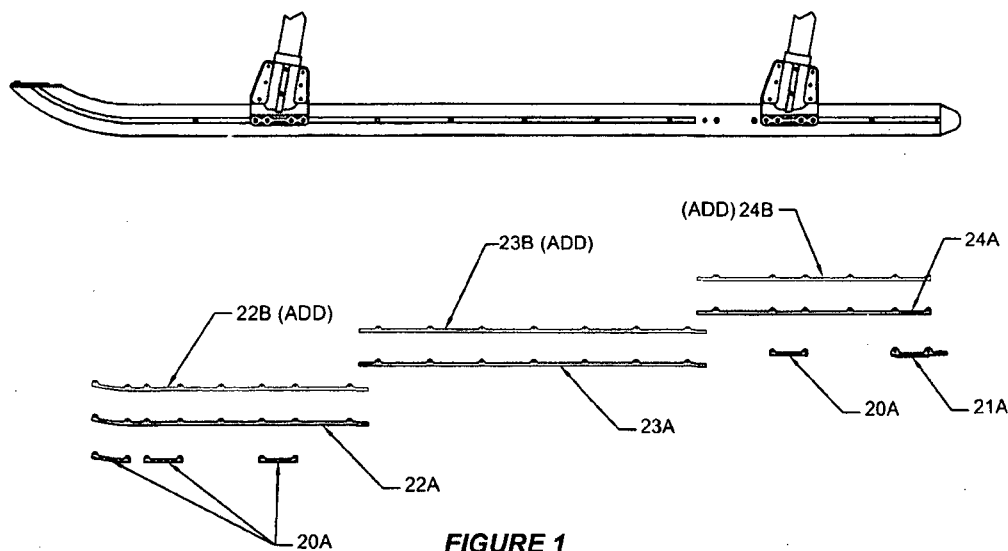
20A			6			D3537-1	WEARPAD (REPLACES D2648-3)	(MODIFY)
21A			1			D3537-3	WEARPAD (REPLACES D3429-1)	(MODIFY)
22A			1	1		D3535-15	WEARSHOE (REPLACES D2656-15)	(MODIFY)
22B			1	1		D3536-15	GASKET	(ADD)
23A			1	1		D3535-23	WEARSHOE (REPLACES D2656-23)	(MODIFY)
23B			1	1		D3536-23	GASKET	(ADD)
24A			1	1		D3535-37	WEARSHOE (REPLACES D2656-37)	(MODIFY)
24B			1	1		D3536-37	GASKET	(ADD)
26A			60			MS27039-1C08	SCREW	(MODIFY)
26B			60			AN960C10L	WASHER	(MODIFY)

WAS:

20A			6			D2648-3	WEARPAD
21A			1			D3429-1	WEARPAD
22A			1	1		D2656-15	WEARSHOE
23A			1	1		D2656-23	WEARSHOE
24A			1	1		D2656-37	WEARSHOE
26A			60			MS27039-1-08	SCREW
26B			60			AN960JD10L	WASHER

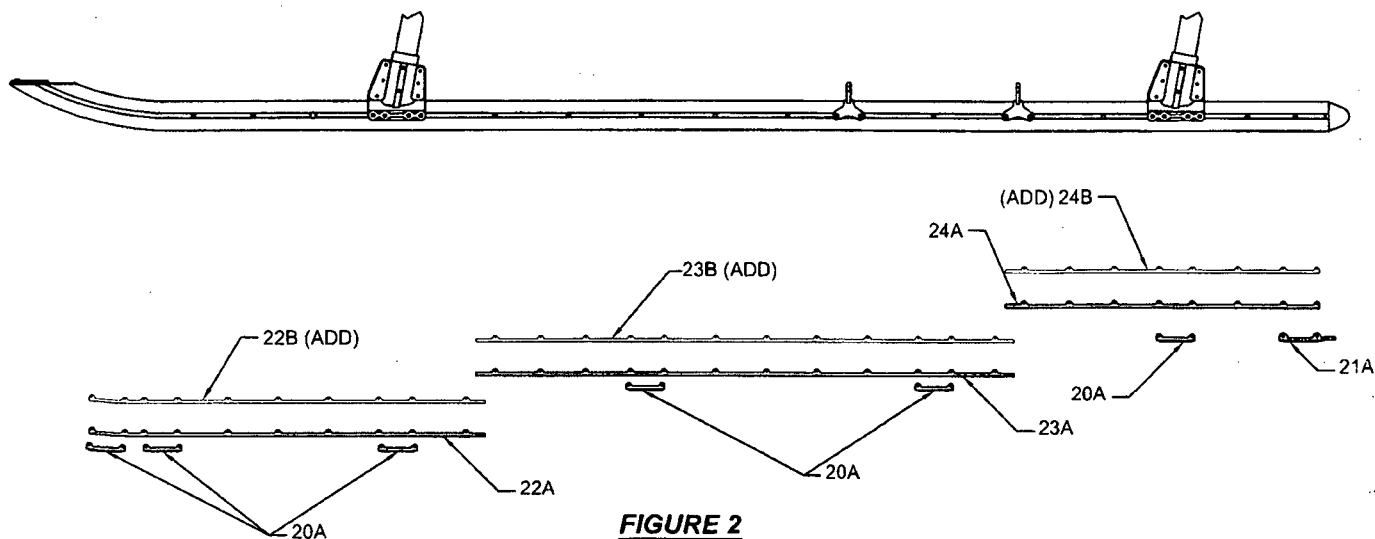
DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<del>HA</del>	DRAWING NO.	REV. 3
MFG. APPR.	N/A	DSI 9440	SHEET 3 OF 4
APPROVED	<del>HA</del>	TITLE	SCALE
DE APPR.	<del>HA</del>	WEARSHOE CHANGE	NTS
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**206 A/B SKIDTUBES**  
(D206-642-111/-112/-211/-212/-213/-214)



**FIGURE 1**

**206 L/L-1/L-3/L-4/407 SKIDTUBES**  
(D206-642-311/-312/-411/-412)



**FIGURE 2**

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<del>---</del>	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9440	SHEET 4 OF 4
APPROVED	<del>---</del>	TITLE	SCALE
DE APPR.	<del>---</del>	WEARSHOE CHANGE	NTS
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## Change Record

PAGE 1 OF 1

Part Number: D206-642-214

Description: SKIDTUBE , RH

[illegible]

# **DART SERVICE INSTRUCTION**

**TO AMEND INSTALLATION INSTRUCTIONS D206-642 REV. L AND  
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-642 REV. 1**

**REF. CANADIAN STC: SH98-4**

**REF. FAA STC: SA00475SE**

**REF. EASA STC: EASA.IM.R.S.01320**

## **INSTRUCTIONS:**

1) FOR D206-642-111/-112/-211/-212/-213/-214 SKIDTUBES @ CHANGE 005 AND SUBSEQUENT, MODIFY THE FOLLOWING:

- a) REPLACE THE D2655 RING WITH THE D3413-1 RING.
- b) AMEND THE PARTS LIST IN SECTIONS 4.1 AND 4.2 OF INSTALLATION INSTRUCTIONS D206-642 REV. L AND SECTIONS 32.10 AND 32.11 OF THE INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-642 REV. 1 AS SHOWN ON SHEET 2.

2) FOR D206-642-311/-312/-411/-412 SKIDTUBES @ CHANGE 006 AND SUBSEQUENT, REVISION B OF THIS DSI **SUPERCEDES** REVISION A (DISCARD REVISION A). MODIFY THE FOLLOWING:

- a) REPLACE THE D206-648-011 GROUND HANDLING KIT WITH THE D206-648-013 GROUND HANDLING KIT.
- b) REPLACE THE D2707-043 AND/OR D2968-043 TOW RING WITH THE D3407-043 TOW RING ASSEMBLY.
- c) REPLACE THE D2655 RING WITH THE D3413-1 RING.
- d) REPLACE THE D2659 GHW LUG WITH THE D3414-041 LUG ASSEMBLY.
- e) AMEND THE PARTS LIST IN SECTIONS 4.3 AND 4.4 OF INSTALLATION INSTRUCTIONS D206-642 REV. L AND SECTIONS 32.12 AND 32.13 OF THE INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-642 REV. 1 AS SHOWN ON SHEETS 3 AND 4.

**NOTE: ALL INSTALLATION FASTENERS FOR THE ABOVE CHANGES HAVE BEEN UPDATED SEE THE AMENDED PARTS LIST FOR DETAILS.**

B	ADDED SHEETS 3-5. ADDED CHANGES TO P/L SECTIONS 4.1, 4.2, 4.3 & 4.4 OF IIN FOR GH RING, SECTIONS 4.3 & 4.4 ALSO UPDATED FOR GHW LUG CHANGES. ICA SECTIONS UPDATED ACCORDINGLY.	AJS	08.10.07
A	NEW ISSUE	AJS	08.09.10
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9421	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE INSTALLATIONS	NTS
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4.1 206 A/B Low Gear Skidtubes (D206-642)  
32.10 206 A/B Low Gear Skidtubes (ICA-D206-642)

ITEM	Qty -111	Qty -112	Qty -141	Qty -143	PART NUMBER	DESCRIPTION
	X				D206-642-111	SKIDTUBE INSTALLATION, LH
		X			D206-642-112	SKIDTUBE INSTALLATION, RH
	1	1	X		D206-642-141	SKIDTUBE
				X	D206-642-143	WEARSHOE KIT
	1	1			D206-651-041	* 206 GHW ADAPTER <sup>(2)</sup>

IS:

34	1	1			AN4C5A	BOLT
35	1	1			AN960C416	WASHER
36	1	1			D3413-1	RING

WAS:

34	1	1			AN4-5A	BOLT
35	1	1			AN960JD416	WASHER
36	1	1			D2655	RING

4.2 206 A/B High Gear Skidtubes (D206-642)  
32.11 206 A/B High Gear Skidtubes (ICA-D206-642)

ITEM	Qty -211	Qty -212	Qty -213	Qty -214	Qty -241	Qty -243	PART NUMBER	DESCRIPTION
	X						D206-642-211	SKIDTUBE INSTALLATION, LH
		X					D206-642-212	SKIDTUBE INSTALLATION, RH
			X				D206-642-213	SKIDTUBE INSTALLATION, LH, THRU BOLT
				X			D206-642-214	SKIDTUBE INSTALLATION, RH, THRU BOLT
	1	1	1	1	X		D206-642-241	SKIDTUBE
						X	D206-642-243	WEARSHOE KIT
	1	1	1	1			D206-651-041	* 206 GHW ADAPTER <sup>(2)</sup>

IS:

34	1	1	1	1			AN4C5A	BOLT
35	1	1	1	1			AN960C416	WASHER
36	1	1	1	1			D3413-1	RING

WAS:

34	1	1	1	1			AN4-5A	BOLT
35	1	1	1	1			AN960JD16	WASHER
36	1	1	1	1			D2655	RING

DESIGN	AJS	<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9421	SHEET 2 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.		SKIDTUBE INSTALLATIONS	NTS
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4.3 206 L/L-1/L-3/L-4/407 Low Gear & 407 High Gear Skidtubes (D206-642)  
 32.12 206 L/L-1/L-3/L-4/407 Low Gear & 407 High Gear Skidtubes (ICA-D206-642)

IS:

ITEM	Qty -311	Qty -312	Qty -341	Qty -343	Qty -013	PART NUMBER	DESCRIPTION
	X					D206-642-311	SKIDTUBE INSTALLATION, LH
		X				D206-642-312	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-341	SKIDTUBE
				X		D206-642-343	WEARSHOE KIT
	1	1			X	D206-648-013	GROUND HANDLING KIT
30	1	1				D3407-043	TOW RING ASSEMBLY
32A	1	1				D3456-1	WASHER
32B	2	2				D3457-1	WASHER
33	1	1				MS21043-4	NUT
34	1	1				AN4C5A	BOLT
35	1	1				AN960C416	WASHER
36	1	1				D3413-1	RING
40					2	D3414-041	LUG ASSEMBLY
41					4	AN3C37A	BOLT
42					8	D2652	BUSHING
43					4	MS21043-3	NUT
44					4	AN960C10	WASHER

WAS:

ITEM	Qty -311	Qty -312	Qty -341	Qty -343	Qty -011	PART NUMBER	DESCRIPTION
	X					D206-642-311	SKIDTUBE INSTALLATION, LH
		X				D206-642-312	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-341	SKIDTUBE
				X		D206-642-343	WEARSHOE KIT
	1	1			X	D206-648-011	GROUND HANDLING KIT
30	1	1				D2707-043 (OR D2968-043)	TOW RING
31	1	1				AN960JD1016	WASHER
32	1	1				AN970-4	WASHER
33	1	1				MS21042-4	NUT (OR MS21042L4)
34	1	1				AN4-5A	BOLT
35	1	1				AN960JD416	WASHER
36	1	1				D2655	RING
40					2	D2659	GHW LUG
41					4	AN3-37A	BOLT
42					8	D2652	BUSHING
43					4	MS21042-3	NUT (OR MS21042L3)
44					4	AN960DJ10	WASHER

DESIGN	AJS	<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9421	SHEET 3 OF 5
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4.4 206L/L-1/L-3/L-4 High Gear Skidtubes (D206-642)  
32.13 206L/L-1/L-3/L-4 High Gear Skidtubes (ICA-D206-642)

IS:

ITEM	Qty -411	Qty -412	Qty -441	Qty -443	Qty -013	PART NUMBER	DESCRIPTION
	X					D206-642-411	SKIDTUBE INSTALLATION, LH
		X				D206-642-412	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-441	SKIDTUBE
				X		D206-642-443	WEARSHOE KIT
	1	1			X	D206-648-013	GROUND HANDLING KIT
30	1	1				D3407-043	TOW RING ASSEMBLY
32A	1	1				D3456-1	WASHER
32B	2	2				D3457-1	WASHER
33	1	1				MS21043-4	NUT
34	1	1				AN4C5A	BOLT
35	1	1				AN960C416	WASHER
36	1	1				D3413-1	RING
40					2	D3414-041	LUG ASSEMBLY
41					4	AN3C37A	BOLT
42					8	D2652	BUSHING
43					4	MS21043-3	NUT
44					4	AN960C10	WASHER

WAS:

ITEM	Qty -411	Qty -412	Qty -441	Qty -443	Qty -011	PART NUMBER	DESCRIPTION
	X					D206-642-411	SKIDTUBE INSTALLATION, LH
		X				D206-642-412	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-441	SKIDTUBE
				X		D206-642-443	WEARSHOE KIT
	1	1			X	D206-648-011	GROUND HANDLING KIT
30	1	1				D2707-043 (OR D2968-043)	TOW RING
31	1	1				AN960JD1016	WASHER
32	1	1				AN970-4	WASHER
33	1	1				MS21042-4	NUT (OR MS21042L4)
34	1	1				AN4-5A	BOLT
35	1	1				AN960JD416	WASHER
36	1	1				D2655	RING
40					2	D2659	GHW LUG
41					4	AN3-37A	BOLT
42					8	D2652	BUSHING
43					4	MS21042-3	NUT (OR MS21042L3)
44					4	AN960DJ10	WASHER

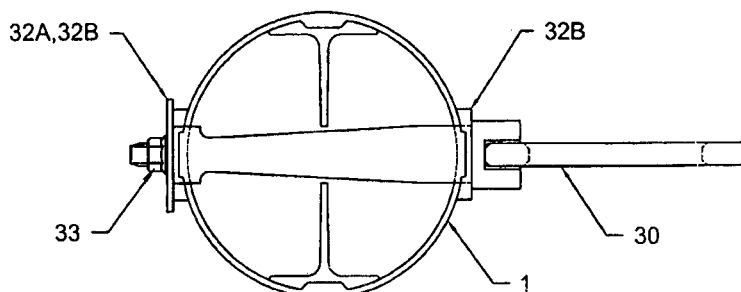
DESIGN	AJS	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9421	SHEET 4 OF 5
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INSTALL TOW RING ASSEMBLY AS SHOWN BELOW (REFER TO DETAIL D OF D206-642 REV. L AND DETAIL D OF ICA-D206-642 REV. 1). AMEND SECTION 3.3 OF OF D206-642 REV. L AND SECTION 32.6 OF ICA-D206-642 REV. 1 ACCORDINGLY.

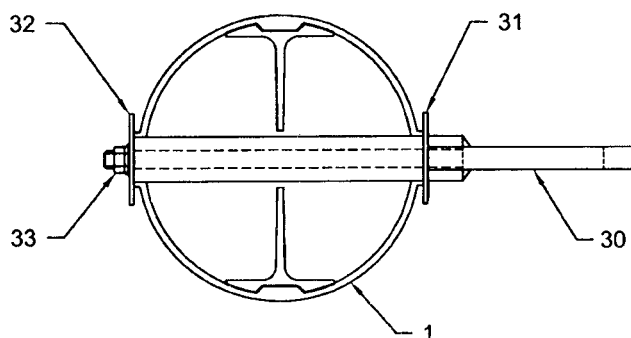
**IS:**

**DETAIL D**  
206L/L-1/L-3/L-4/407 ONLY

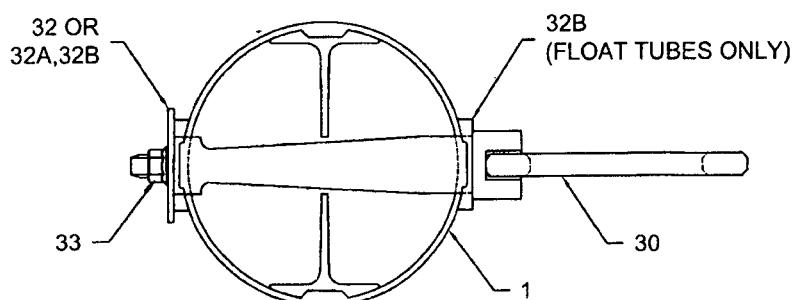


**WAS:**

**DETAIL D**  
206L/L-1/L-3/L-4/407 ONLY



**OR**



NO PICTORIAL CHANGE REQUIRED FOR D3413-1 RING AND/OR D3414-041 LUG ASSEMBLY LUG CHANGE.

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DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9421	SHEET 5 OF 5
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Date: Thursday, 19/02/2009 1:59:24 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B

Job Number: 45908A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install D2680-041 Nut Plate as per Dwg D2650

23.0

QC9 +2C10

VISUAL WELDING INSPECTION



QC10 - 09/02/07



Comment: VISUAL WELDING INSPECTION

QC9 - PD 09-02-27

24.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/02/07

25.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

BL 09-03-2

26.0

POWDER COATING

POWDER COATING



M109996



Comment: POWDER COATING

Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.3. Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs.

START TIME:

3:40

OVEN TEMPERATURE:

320°

FINISH TIME:

4:10

FL 09/03/07

27.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



41



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-03-04

28.0

D26483

Wearpad



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 D2648-3

Wearpad

1344518

41

09-03-04

Date: Thursday, 19/02/2009 1:59:24 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B

Job Number: 45908A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

D265613

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2656-13

Wearshoe

B42772

JS

30.0

D265621

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2656-21

Wearshoe

B42776

JS

31.0

D265633

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2656-33

Wearshoe

B20756

\* JS

32.0

D34291

Wearpad



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3429-1

Wearpad

B44169

JS

33.0

ALS41032130

Insert



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

44 ALS4-1032-130 Inserts

M108606

\*

or (see QSI 017)

JS 09-03-04 (X)

Date: Thursday, 19/02/2009 1:59:24 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B

Job Number: 45908A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

AN960JD10L

Washer



Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

46 AN960JD10L

Washer

M109632

JJ

35.0

MS27039108

Screw



Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

46 MS27039-1-08

Screw

M110467

JJ

36.0

D26511

Plug



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

18 D2651-1

Plugs

B343990

JJ

37.0

D26513

O-Ring



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

18 D2651-3

O-Rings

B343844

JJ

38.0

MS27039406

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 MS27039-4-06

Screw

M109061

JJ

39.0

AN960JD416

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN960JD416

Washer

M108161

JJ

09-03-04

Date: Thursday, 19/02/2009 1:59:24 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B

Job Number: 45908A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1]

1- Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing

✓ wearpad/wearplate.

A/R Sikaflex-291 11109883

Sikaflex expire date: 09/14

✓ 2-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D2650  
(D2650-3 detail). Clean excess adhesive.

✓ 3-Install MS27039-4-06 Screw as per DEO 9153.

111 09-03-04 v1

41.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2646 Aft Cap 1341435

111

42.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive

A/R Sikaflex-291 11109883

Sikaflex expire date: 09/11

111 09-03-04 20

2-Wing Walk as per Dwg D2650-3 and QSI 005 4.4

Batch: 1110454

111 09-03-06

20

43.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

111 09/03/06 20

44.0

QC5

INSPECT WORK TO CURRENT STEP














Comment: INSPECT WORK TO CURRENT STEP

111 09/03/06 20

Date: Thursday, 19/02/2009 1:59:02 PM  
User: Julie Dawson

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: 206 A/B HIGH GEAR SKIDTUBE
<b>Job Number</b>	: 45908		
<b>Estimate Number</b>	: 10172		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D206642214
<b>This Issue</b>	: 19/02/2009 S.O. No. :	<b>Drawing Number</b>	: N/A
<b>Prsht Rev.</b>	: NC	<b>Project Number</b>	: N/A
<b>First Issue</b>	: // Type : SKIDTUBES	<b>Drawing Revision</b>	: L
<b>Previous Run</b>	: 42341	<b>Material</b>	:
<b>Written By</b>	:	<b>Due Date</b>	: 09/03/2009 Qty: 1 Um: Each
<b>Checked &amp; Approved By</b>	: <u>Julie Dawson</u>		
<b>Comment</b>	: Est Rev:K 05.07.14 ECN 847 & 901, Add Tow Ring and GHW Kit KJ/CP/JLM Est Rev:L 07-12-04 ECN 1080p DD verified by:		
<b>Additional Product</b>			
Job Number: 			
<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>	
1.0	DC	DOCUMENT CONTROL	
			
<b>Comment:</b> DOCUMENT CONTROL Photocopy bluefile & type labels per PPP206-642-214 CHG004			
2.0	PACKAGING 1	PACKAGING RESOURCE #1	
			
<b>Comment:</b> PACKAGING RESOURCE #1 Pick Packing Kit			
3.0	45908A	HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B	
			
<b>Comment:</b> Sub-Component HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B 1 x D206-642-241 Batch <u>45908 A</u> SP			
4.0	D206651041	206A/B GHW	
			
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Packing Kit Qty Part Number Description Batch 1 D206-651-041 GHW Kit <u>45908 A</u> CHG001 1 D206-642-241(REF) <u>43117</u> SP			
5.0	D2652	Bushing	
			
<b>Comment:</b> Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s) Pick: Packing Kit Qty Part Number Description Batch 16 D2652 Bushing <u>43900</u> 01/3/19 SP			

Date: Thursday, 19/02/2009 1:59:02 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B HIGH GEAR SKIDTUBE

Job Number: 45908

Part Number: D206642214

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 D2655 Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2655 Tow Ring

B3475a

SP

7.0 D2652 Saddle, RH Fwd Aft Out 206



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2665-2 Saddle

B45808

SP

8.0 D2662 Saddle, RH Fwd Aft In 206



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2666-2 Saddle

B45809

SP

9.0 D26672 Saddle, RH Aft Out 206



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2667-2 Saddle

B16272

SP

10.0 D26682 Saddle, RH Aft In 206



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2668-2 Saddle

B11170

SP

11.0 D2712 Set Screw



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

5 D2712 Set Screw

B43816

9/3/9

SP

(K)

Date: Thursday, 19/02/2009 1:59:02 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B HIGH GEAR SKIDTUBE

Job Number: 45908

Part Number: D206642214

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D2884

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2884 saddle spacer B237444

sd

13.0

D2885

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Saddle Spacer

sd

14.0

AN341A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN3-41A Bolt M110467

sd

15.0

AN45A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 AN4-5A Bolt M109061

sd

16.0

AN46A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN4-6A Bolt M109545

sd

17.0

AN57A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN5-7A Bolt M110625

9/3/9

sd



Date: Thursday, 19/02/2009 1:59:02 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B HIGH GEAR SKIDTUBE

Job Number: 45908

Part Number: D206642214

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN511A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 AN5-11A

Bolt M110363

SP

19.0

AN532A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

2 AN5-32A

Bolt M110363

SP

20.0

AN644A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

2 AN6-44A

Bolt M105211

SP

21.0

AN960JD10

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 AN960JD10

Washer M110139

SP

22.0

AN960JD416

Washer



Comment: Qty.: 25.0000 Each(s)/Unit Total: 25.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

25 AN960JD416

Washer M110523

9/3/9

SP

Date: Thursday, 19/02/2009 1:59:02 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B HIGH GEAR SKIDTUBE

Job Number: 45908

Part Number: D206642214

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-214

Location:

31.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



12/09/03/13  
mf  
09-03-13












1345908 A

642-274

Dart Aerospace Ltd.

Date: Thursday, 19/02/2009 1:59:24 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B
<b>Job Number</b>	: 45908A	<b>Part Number</b>	: D206642241
<b>Estimate Number</b>	: 10163	<b>Drawing Number</b>	: D2650 REV F
<b>P.O. Number</b>	:	<b>Project Number</b>	: N/A
<b>This Issue</b>	: 19/02/2009 S.O. No. :	<b>Drawing Revision</b>	: F
<b>Prsht Rev.</b>	: NC	<b>Material</b>	:
<b>First Issue</b>	: // Type : SKIDTUBES	<b>Due Date</b>	: 09/03/2009 Qty: 1 Um: Each
<b>Previous Run</b>	: 45907A		
<b>Written By</b>	:		
<b>Checked &amp; Approved By</b>	JLD 09.02.09		
<b>Comment</b>	: Est Rev:M 04.12.02 Revised procedural steps KJ/JLM		
<b>Additional Product</b>			
Job Number: 			
<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>	
1.0	DC	DOCUMENT CONTROL	
			
<b>Comment:</b> DOCUMENT CONTROL Photocopy bluefile & type labels per PPP D206-642-241 CHG003			
2.0	D2620	Skidtube, 206 Skidtube	
			
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2620 Bent Tube 3" OD 44502 SL 9-2-20			
3.0	D32861	Doubler	
			
<b>Comment:</b> Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s) Pick: Qty Part Number Description Batch 2 D3286-1 Doubler 3414286 ② H 9-2-23			
4.0	D2647	Cap	
			
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2647 Fwd Cap 343846 BB 9-2-20			
5.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1	
			
<b>Comment:</b> LANDING GEAR RESOURCE 1 1-Deburr Fwd edge of tube SL 9-2-20			

Date: Thursday, 19/02/2009 1:59:24 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B

Job Number: 45908A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

2- Remove ridge on inside of Fwd edge of tube as per Dwg D2650 *SL 9-2-20*

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

Pick:

Qty Part Number Description Batch

A/R Aluminum Rod *m110676/m109213 BE 9-2-20*

4-Grind weld flush to cap on top surface only. *BE 9-2-20*

5-Cut Aft end as per dwg 2650 from front of tube and Deburr

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D2650

7-Open holes for Aft end cap as per Dwg D2650 with #30 Drill Bit using DT8025.

8-Drill pilot holes using Dt 8167.

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.

10- Drill D3286-1 dcubler rivet holes in tube using # 40 drill, spot drilling doubler at the same time.

11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D2650

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

14-Remove indexing edge using DT8741 as per Dwg D2650

15-C'sink GHW rivet holes as per Dwg D2650

6.0

QC6

DIMENSIONAL CHECK



*holes are within 0.005".  
From side to side*



Comment: DIMENSIONAL CHECK

*5 09/02/24 @*

Date: Thursday, 19/02/2009 1:59:24 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B

Job Number: 45908A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open crossbolt holes to Ø0.3125"

2-Drill pilot holes using DT8028-3, then open to Ø0.297" as per Dwg D2650. Open Aft cap hole #6.

3-Deburr tube and blow out chips from inside the tube

3  
09/02/24

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

① H 9-2-25

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP 9-2-25

10.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2650, D2650-3 Drilling Detail (without cutting fluid)

2-C'sink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr and blow out all chips from inside the tube

H  
9-2-25

11.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

holes are 'about 0.010" from side 2 s.o.e.

8 09/02/25 (X)

12.0

CR3212404

Cherry Rivet



Comment: Qty.: 52.0000 Each(s)/Unit Total: 52.0000 Each(s)

Pick:

Qty Part Number

Description Batch

52 CR3212-4-04 Rivet

M 7225-3-44 110225 (54) H 9-2-25

Date: Thursday, 19/02/2009 1:59:24 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B

Job Number: 45908A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D26543

Web



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2654-3

Web

B45910

①

M 9-2-25

14.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Locate, install and rivet doublers as per Dwg D2650. Micro-shave rivets as required

2-Bond D2654-3 web in place as per QSJ 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting

Start Date: 9-2-25 Time: 11:20

Finish Date: 09-2-26 Time: 7:40AM

Pick:

Qty Part Number

Description Batch

A/R Sikaflex-291

1109973

Sikaflex expire date:

9-7-7

M

9-2-25

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9-2-26 ①

16.0

D2649

Cross Bolt Spacer



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick:

Qty Part Number

Description Batch

18 D2649

Crossbolt spacer

B44364

BE 09/02/26

17.0

D32863

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D3286-3

Spacer

B44362

BE 09/02/26

Date: Thursday, 19/02/2009 1:59:24 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B

Job Number: 45908A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-remove alodine from around hole and prepare for welding

BE 09/02/26

2-Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

Qty Part Number Description Batch

A/R Aluminum Rod ~~M110~~ M1109213 BE 09/02/26

3-Grind welds flush as per Dwg D2650.

K a-2-26

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D2650. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/RSS Rod ~~NONE~~ BE 09/02/26

5-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D2650. Deburr

K a-2-26

19.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CCR264SS3-3 Rivets M110625

②

K a-2-26

20.0

CR3212403

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Cherry Rivet

batch: M110139

②

K a-2-26

21.0

D2680041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2680-041 Nut Plate

B34599

①

K a-2-26

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>					
<b>Root Cause</b>	<b>Date</b>	<b>Step</b>	<b>Qty</b>	<b>Description of work order update or Non-conformance</b>	<b>Initial Chief Eng</b>	<b>Action Description</b>	<b>Sign &amp; Date</b>	<b>Verification</b>	<b>QC Inspector</b>		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY												
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other	



**Work Order ID 101421****\*101421\***

May-10-13 9:42:52 AM

Accept

**\*N9000040100\***Setup Start **\*NS1\***Stop **\*NS2\***

Item ID: D206-642-214

Revision ID:

Item Name: Skidtube RH

Start Date: 5/10/13 Start Qty: 1.00

**\*1\***

Required Date: 5/10/13 Req'd Qty: 1.00

**\*1\***

Reference: rework

Cust Item ID:

Customer:

Run Start **\*NR1\***Stop **\*NR2\***

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

IIN-D206-642

0

0.00

100

DOCUMENT CONTROL

0.00

**\*100\***

DC

Document Control

Memo

Photocopy bluefile &amp; type labels per PPP206-642-214 CHG002

0.00

101

**\*101\***

HandFinish

Hand Finishing

Memo

PULL FROM STOCK:  
1 X D206-642-214 B45908

0.00

PER DS19440  
REMOVE ALL OLD WEARPLATES AND DISCARD  
REPLACE WITH SS WEARPLATES

MS 130570